

Millermatic® 212

Issued August 2007 • Index No. DC/12.46

**MIG Arc Welding
Power Source** 

Quick Specs

Industrial Applications

Light Fabrication
Garages/Body Shops
Farm/Ranch
Vocational/Technical Schools

Processes

MIG (GMAW)
Flux Cored (FCAW)

Input Power

200(208)/230 V

Rated Output 160 A at 24.5 VDC, 60% Duty Cycle

Max. Open-Circuit Voltage 34.5 VDC

Amperage Range 30–210 A

Wire Feed Speed 50–700 IPM (1.3–17.8 m/min)

Weight 190 lb (86 kg)

The Power of Blue.®

Seven taps provide wider welding range of 30–210 amps with improved high and low ends to weld materials from 22 gauge up to 3/8 in (9.5 mm) thick in a single pass.

NEW! Angled, dual-gear driven, cast aluminum drive system features no-tool, quick-change reversible drive rolls and an easy-to-set, scaled tension knob. [See page 3 for more information.](#)

NEW! Patent-pending EZ-Change™ Low Cylinder Rack allows operators to easily roll cylinders on and off of rack—no need to lift cylinders. [See page 3 for more information.](#)



Add the Spoolmate™ 3035 spool gun for aluminum welding. Easy to install with direct hook up. And with Miller's exclusive Gun-On-Demand,™ simply pull the trigger for either gun and you're ready to weld. No time wasted toggling switches!

NEW! Thermal overload protection shuts down unit and activates **over temperature light** if airflow is blocked or duty cycle is exceeded. Automatically resets when fault is corrected and unit cools.



NEW! EZ-Access™ Consumable Compartment and Parameter Chart — set weld parameters right the first time with convenient new flip-down compartment that provides fast access to parameter chart and consumables. [See page 3 for more information.](#)

NEW! Larger work area — now with longer 15-ft M-25 gun.

TRUE BLUE
3 YR. WARRANTY

Welder is warranted for 3 years, parts and labor.
Original main power rectified parts are warranted for 5 years.
Gun warranted for 90 days, parts and labor.

Less weld cleanup with Active Arc Stabilizer™ — patented Miller design provides excellent starts proven superior to the competition.

MADE IN USA
APPLETON, WI



Miller

Miller Electric Mfg. Co.

An Illinois Tool Works Company
1635 West Spencer Street
Appleton, WI 54914 USA

International Headquarters

Phone: 920-735-4505
USA FAX: 920-735-4134
Canadian FAX: 920-735-4169
International FAX: 920-735-4125

Web Site

www.MillerWelds.com



Specifications (Subject to change without notice.)

CV DC 1 Phase

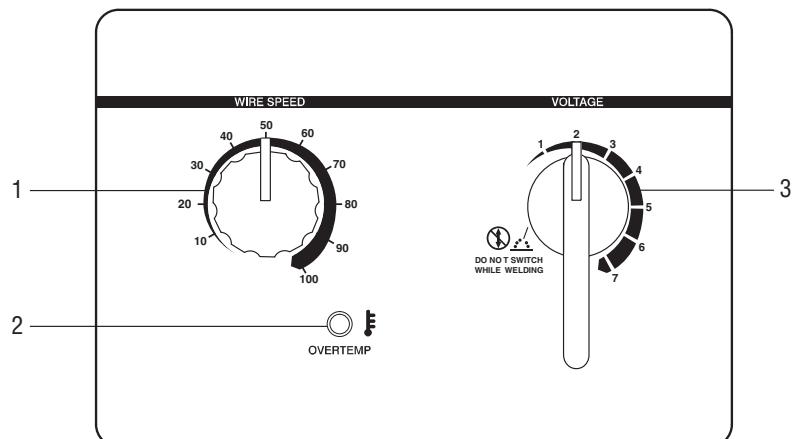
Rated Output	Amperage Range	Max. Open-Circuit Voltage	Amps Input at Rated Output, 60 Hz				Wire Type and Diameter	Wire Feed Speed	Max. Spool Size	Dimensions	Net Weight
			200(208) V	230 V	KVA	KW					
160 A, 24.5 VDC at 60% Duty Cycle	30–210 A	34.5	31.2 2.1*	27.1 1.8*	6.36 0.51*	5.45 0.26*	Solid/Stainless Steel: .023–.035 in (0.6–0.9 mm) Flux Cored: .030–.045 in (0.8–1.2 mm)	50–700 IPM (1.3–17.8 m/min)	12 in (305 mm)	H: 30 in (762 mm) W: 19 in (483 mm) D: 40 in (1016 mm)	190 lb (86 kg)
210 A, 23 VDC at 30% Duty Cycle											

*While idling.

Note: Operating Temperature Range: -4° to +104° F (-20 to +40° C) Storage Temperature Range: -22° to +122° F (-30 to +50° C)

 Certified to both the Canadian and U.S. Standards for welding equipment.

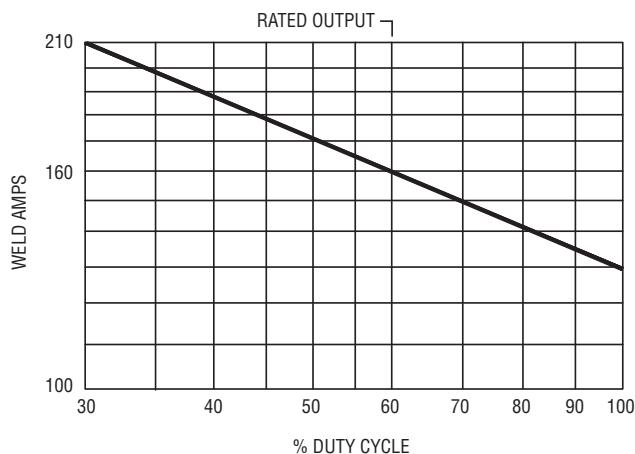
Control Panel



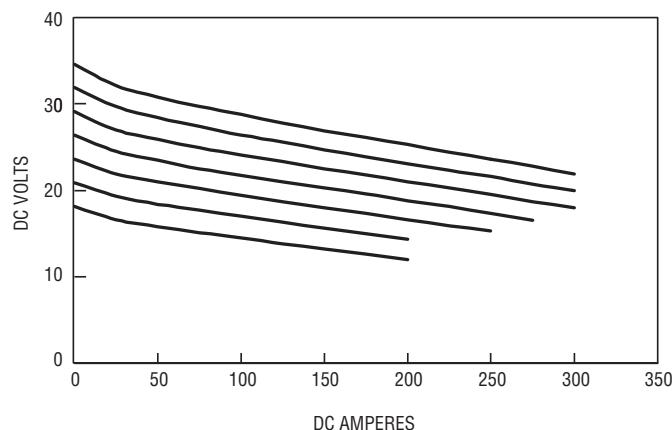
1. Wire Feed Speed Control
2. Overtemp Light
3. Voltage Control

Performance Data

DUTY CYCLE CHART



VOLT/AMP CURVES



Standard Fully Loaded Features

EZ-Change™ Low Cylinder Rack

- **NEW!** Patent-pending design—operators no longer need to lift cylinders. Cylinders now easily roll on and off our EZ-Change™ Low Cylinder Rack.



Angled Wire Drive

- Angled industrial aluminum dual-gear drive system significantly improves wirefeeding and runs large spools of wire.
- Allows quick change of drive rolls without tools.
- Drive roll storage—no more lost drive rolls, extra drive rolls are conveniently stored next to drive motor.
- Operators no longer bump into and bend MIG gun and gun liner.



Dual Front Handles

- Exclusive split handle with rubber grips designed to move machine easily and allow work lead and MIG gun to be stored independently.
- Handles provide protection for front panel and MIG gun during transportation.



EZ-Access™ Consumable Compartment and Parameter Chart

- Convenient flip-down compartment holds parameter chart and storage for consumables.



Optional Fully Loaded Features

Elevated Gun and Cable Rack

#300 335

- No more running over spool gun cables or cables dragging on the floor.
- Tangle-free, independent way to store spool gun cables, keeping them off of the floor.
- Elevated Gun and Cable Rack can be used with either a single or dual cylinder rack. (Elevated Gun and Cable Rack is included with the Dual EZ-Change™ Low Cylinder Rack.)



Dual EZ-Change™ Low Cylinder Rack with Elevated Gun and Cable Rack

#300 337

- Dual cylinder rack allows for easy storage for two cylinders.
- EZ-Change™ Low Cylinder rack eliminates the need to lift cylinders on and off cylinder rack.
- No more running over spool gun cables or cables dragging on the floor.
- Tangle-free, independent way to store spool gun cables, keeping them off of the floor.



Genuine Miller Accessories

M-25 Replacement Gun

#169 594 10 ft (3 m)

#169 596 12 ft (3.7 m)

#169 598 15 ft (4.6 m) standard

Gun shipped to run .030–.035 in (0.8–0.9 mm) wire.



Spoolmate™ 3035 Spool Gun #195 016

Spool gun for aluminum and other wires. 4 in spools; .023–.035 in (0.6–0.9 mm) aluminum, steel and stainless steel. Rated at 150 amps, 60% duty cycle with 20 ft (6 m) cable assembly.

Spoolmate™ 3035 25 ft Extension Cable Kit

#194 996

Extends Spoolmate 3035 an additional 25 ft (7.6 m) from power source.

Heavy-Duty Barrel for Spoolmate 3035

#195 375

Use for demanding applications, rated at 200 A, 60% duty cycle.

Adapter Cable #195 287

Allows Spoolmatic® 15A or 30A to be used with Millermatic 212.

Note: WFS is controlled at the machine, not the gun.



Protective Cover with

Helmet Bag #195 142

Features side pocket, helmet bag and Flame graphic on side panel.

Argon/Mixed Gas Regulator and Gas Hose #195 050

(Order from Miller Service Parts.)

CO₂ Regulator/Flow Gauge #212 492

Required if using 100% CO₂ gas.

(Order from Miller Service Parts.)



Consumables (Order from Miller Service Parts.)

For M-25 Gun



Contact Tips

#087 299 .023/.025 in (0.6 mm)

#000 067 .030 in (0.8 mm)

#000 068 .035 in (0.9 mm)

#000 069 .045 in (1.1 mm)

#187 117 .035 in (0.9 mm) heavy-duty tip

#187 118 .045 in (1.2 mm) heavy-duty tip

Tapered Contact Tips

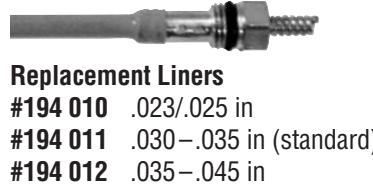
#176 797 .030 in (0.8 mm)

#176 793 .035 in (0.9 mm)

#176 794 .045 in (1.2 mm)



Contact Tip Adapter **#169 728**



Replacement Liners

#194 010 .023/.025 in

#194 011 .030–.035 in (standard)

#194 012 .035–.045 in



Nozzles

Note: Flush or stickout nozzles should be used for the short-circuit process.

#200 258 Standard

1/2 in (13 mm) diameter orifice. Nozzle flush with contact tip.

#169 726

5/8 in (16 mm) diameter orifice.

Nozzle flush with contact tip.

#169 727

5/8 in (16 mm) diameter orifice. Contact tip sticks out of nozzle 1/8 in (3.2 mm).

#169 724

1/2 in (13 mm) diameter orifice. Contact tip recessed 1/8 in (3.2 mm) into nozzle.

#169 725

5/8 in (16 mm) diameter orifice. Contact tip recessed 1/8 in (3.2 mm) into nozzle.

Spot Nozzles

#176 238 Flat

#176 240 Inside corner

#176 242 Outside corner

Tapered Nozzles

Note: Tapered tips are recommended when using a tapered nozzle.

#176 243 3/8 in (9.5 mm) diameter orifice

#178 386 11/32 in (8.7 mm) diameter orifice



Gun Convenience Kit **#193 975**

Contains:

5 – .035 in (0.9 mm) contact tips (#000 068)

5 – .045 in (1.2 mm) contact tips (#000 069)

2 – Tip adapters (#169 728)

1 – Nozzle adapter (#169 729)

3 – O-rings (#170 468)

2 – Shock washers (#169 730)

1 – 5/8 in (16 mm) diameter orifice nozzle (#169 726)

Drive Rolls

Note: Drive roll kits include two drive rolls and an inlet guide.

V-Grooved Drive Roll Kits (solid wire)

#204 579 .030 & .035 in (0.8 & 0.9 mm) Combination (Reversible)

#087 131 .023/.025 in (0.6 mm)

#079 594 .030 in (0.8 mm)

#079 595 .035 in (0.9 mm)

V-Knurled Drive Roll Kits

(Flux Cored or difficult-to-feed wire)

#079 606 .035 in (0.9 mm)

For Spoolmate™ 3035 Gun



Contact Tips (5 per package)

#199 730 For .023/.025 in (0.6 mm) wire.

#186 419 For .030 in (0.8 mm) wire.

#186 406 For .035 in (0.9 mm) wire.



Nozzle **#186 405**



Drive Roll (1)

#199 731 For .023 in (0.6 mm) wire.

#186 413 For .030/.035 in (0.8/0.9 mm) wire.



Push Roll (1)

#199 732 For .023 in (0.6 mm) wire.

#186 414 For .030/.035 in (0.8/0.9 mm) wire.

Ordering Information

Steel Configuration

Stock No.	Description	Qty.	Price
Millermatic® 212	#907 324 200(208)/230 V, 60 Hz		
V-Groove Drive Roll Kits (solid wire)	#087 131 .023/.025 (0.6 mm) #079 594 .030 (0.8 mm) #079 595 .035 (0.9 mm) #079 596 .045 (1.2 mm)		
V-Knurled Drive Roll Kits (flux cored)	#079 606 .035 (0.9 mm) #079 607 .045 (1.2 mm)		
Contact Tips (10 per package)	#087 299 .023/.025 (0.6 mm) #000 067 .030 (0.8 mm) #000 068 .035 (0.9 mm) #000 069 .045 (1.2 mm)		
Nozzles	#169 724 1/2 in (13 mm) diameter, 1/8 in (3.2 mm) recessed #169 725 5/8 in (16 mm) diameter, 1/8 in (3.2 mm) recessed #200 258 1/2 in (13 mm) diameter, flush. <i>Included with standard configuration</i> #169 726 5/8 in (16 mm) diameter, flush #169 727 5/8 in (16 mm) diameter, 1/8 in (3.2 mm) exposed		

Aluminum Configuration

Millermatic® 212 Spool Gun Package (Also includes standard M-25 MIG gun)	#951 068 200(208)/230 V, 60 Hz with Spoolmate™ 3035, dual cylinder rack, elevated gun and cable rack, regulator and hose		
Spool Gun Drive Roll	#199 731 .023 (0.6 mm) #186 413 .030/.035 (0.8/0.9 mm)		
Spool Gun Push Roll	#199 732 .023 (0.6 mm) #186 414 .030/.035 (0.8/0.9 mm)		
Spool Gun Contact Tips (5 per package)	#199 730 .023/.025 (0.6 mm) #186 419 .030 (0.8 mm) #186 406 .035 (0.9 mm)		
Spool Gun Nozzle	#186 405		

For M-25 gun consumables and Millermatic 212 drive rolls see steel configuration chart above.

Accessories

Gun Convenience Kit for Steel	#193 975 <i>(Order from Miller Service Parts.)</i>		
M-25 Gun	#169 594 10 ft (3 m), .023–.035 in (0.6–0.9 mm) #169 596 12 ft (3.7 m), .023–.035 in (0.6–0.9 mm) #169 598 15 ft (4.6 m), .023–.035 in (0.6–0.9 mm)		
Spoolmate™ 3035 Spool Gun	#195 016 Spool gun for aluminum		
Spoolmate™ 3035 25 ft Extension Cable Kit	#194 996		
Heavy-Duty Barrel for Spoolmate™ 3035	#195 375 200 A, 60% Duty Cycle		
Adapter Cable	#195 287 Allows Spoolmatic® 15A or 30A to be used with Millermatic 212		
Dual EZ-Change™ Low Cylinder Rack with Elevated Gun and Cable Rack	#300 337		
Elevated Gun and Cable Rack	#300 335 For use with single cylinder rack. <i>(Included with Dual EZ-Change Low Cylinder Rack.)</i>		
Protective Cover with Helmet Bag	#195 142 Features side pocket, helmet bag and Flame graphic		
Argon/Mixed Gas Regulator and Gas Hose	#195 050 <i>(Order from Miller Service Parts.)</i>		
CO ₂ Regulator/Flow Gauge	#212 492 Required if using 100% CO ₂ gas. <i>(Order from Miller Service Parts.)</i>		

Date:

Total Quoted Price:

Distributed by:

